

Work Order ID 86572

July-05-12 10:52:00 AM

\*86572\*

Page 1

Item ID: D350-591-312

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step, Long RH

Start Date: 7/05/12 Start Qty: 5.00

\*5\*

Cust Item ID:

Required Date: 7/20/12 Req'd Qty: 5.00

\*5\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG002  
NON EUROCOPTER

110

0.00

\*110\*

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg  
D3272

A/R Aluminum Rod 1122358  
1122431

3-Grind End Plate flush

for MLT 12-10-25  
(5)

5 12.10.11  
12.10.15

**\*86572\***

July-05-12 10:52:00 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 7/05/12      **Start Qty:** 5.00      **\*5\***

**Cust Item ID:**

**Required Date:** 7/20/12      **Req'd Qty:** 5.00      **\*5\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

### Operation Description

### Set Up/ Run Hours

**Tool ID****Tool #**

Plan Code
--------------

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

120

QC9- Inspect visual per QSI004- Fusion Welds

0,00

**\*120\***

QC

## Memo

0.00

## Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

## Memo

0.00

## Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

## HandFinish

## Memo

0.00

## Hand Finishing

107

Work Order ID 86572

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Item ID: D350-591-312

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step, Long RH

Start Date: 7/05/12 Start Qty: 5.00 \*5\*

Cust Item ID:

Required Date: 7/20/12 Req'd Qty: 5.00 \*5\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				5	0		12-10-18
*150*									
QC	Memo	0.00							
Quality Control									
180	Large Fab	0.00				5	0		12-10-18
*180*									
Large Fab	Memo	0.00							12-10-23
Large Fab	1-Assemble Leg Assembly as per Dwg D3272								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod M122358								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg								



# Work Order ID 86572

**\*86572\***

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July-05-12 10:52:00 AM

Item ID: D350-591-312 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Heli-Access-Step, Long RH  
 Start Date: 7/05/12 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 7/20/12 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00							
200 <b>*200*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							
210 <b>*210*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							



# Work Order ID 86572

\*86572\*

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July-05-12 10:52:00 AM

Item ID: D350-591-312 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Heli-Access-Step, Long RH  
 Start Date: 7/05/12 Start Qty: 5.00 \*5\* Cust Item ID:  
 Required Date: 7/20/12 Req'd Qty: 5.00 \*5\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*220*									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:45								
	OVEN TEMPERATURE: 320 °F								
	FINISH TIME: 2:15								
230	Wing Walk as per dwg QSI005 4.4 Batch M122586p0								
*230*									
HandFinish	Memo	0.00							
Hand Finishing									
240	QC3- Inspect Part Finish	0.00							
*240*									
QC	Memo	0.00							
Quality Control									

M122878

5x4 ✓ 12/10/23

5xRH 12/10/23

5 RH 12-10-24



**Work Order ID 86572****\*86572\***

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July-05-12 10:52:00 AM

Item ID: D350-591-312

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Heli-Access-Step, Long RH

Start Date: 7/05/12 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 7/20/12 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

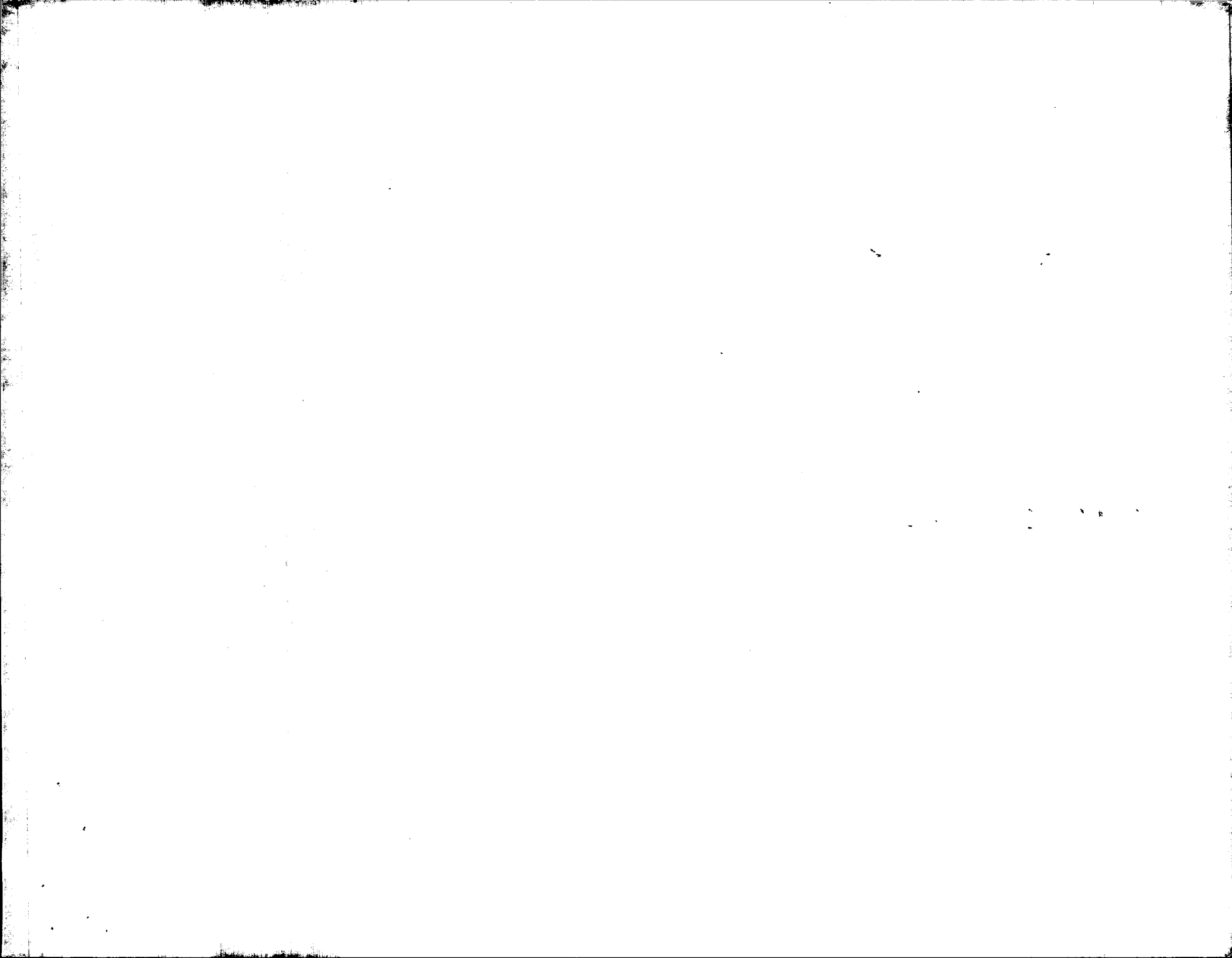
**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 <b>*250*</b> Packaging Packaging	Pick Kit  Memo	0.00  0.00				(S)		12/10/26	SP
260 <b>*260*</b> QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00				(S)			
270 <b>*270*</b> Packaging Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPPD350-591-312 Location: <u>81</u>	0.00  0.00				(S)		12/10/26	SP



# Work Order ID 86572

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Item ID: D350-591-312

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step, Long RH

Start Date: 7/05/12 Start Qty: 5.00 **\*5\***

Cust Item ID:

Required Date: 7/20/12 Req'd Qty: 5.00 **\*5\***

Customer:

Reference:

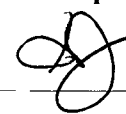
Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_


Run Start **\*NR1\***

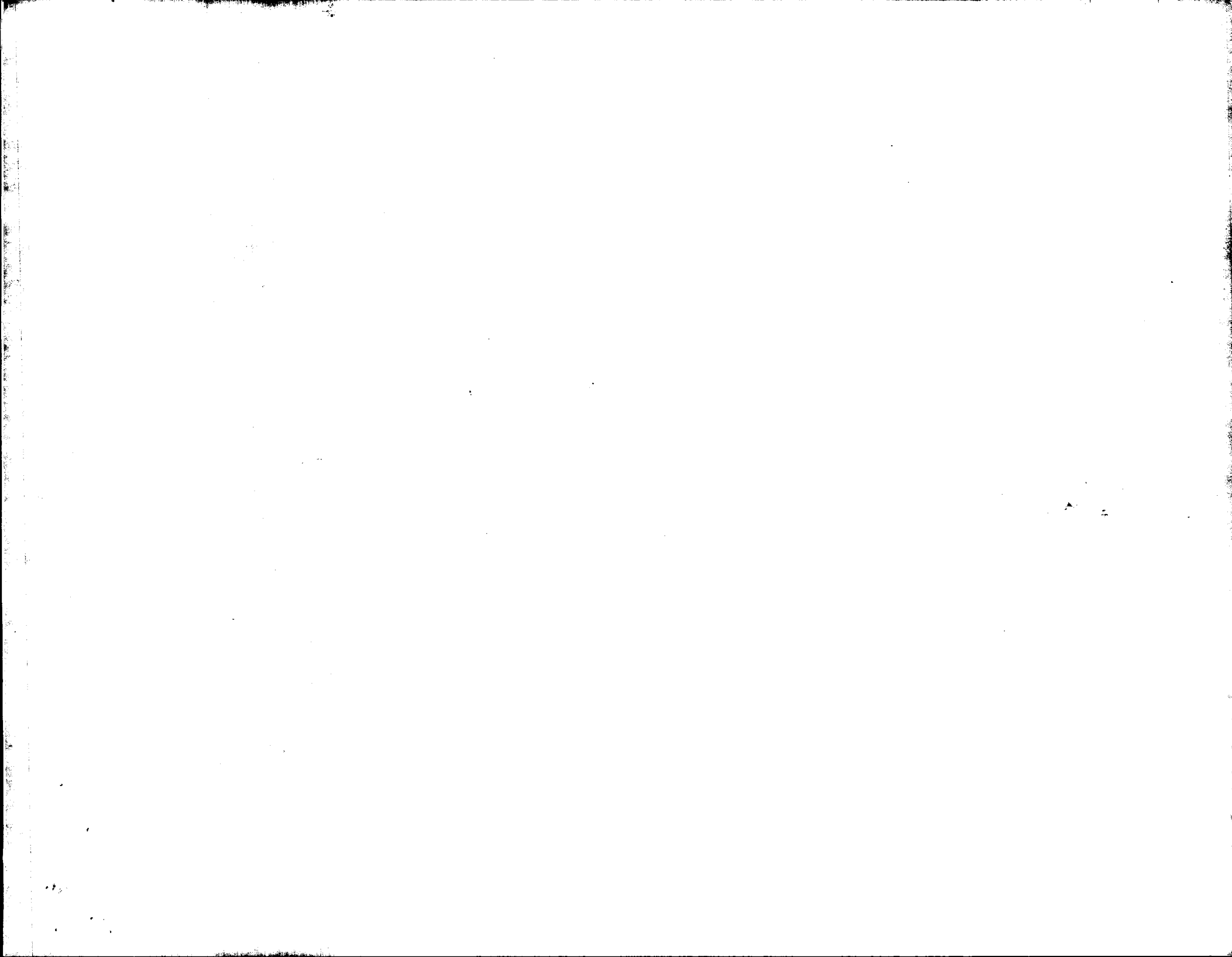
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

12/10/31 

 12-10-30



# Picklist Print

July-05-12 10:51:59 AM

Page 1

Work Order ID: 86572  
 Parent Item: D350-591-312  
 Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/05/12  
 Start Qty: 5.00  
 Required Date: 7/20/12  
 Required Qty: 5.00

Comments: IPP Rev:A04.03.22New issue KJ/RF  
 IPP Rev:B 07-06-09 Added D3572-1 JLM  
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC  
 IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD  
 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>D319410-011</b> Step Modification		Manufactured	No				Each	0.0000	1	5			SNP
<b>D3272-1</b> Step*		Manufactured	No			110	Each	5.0000	1	5			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST	B86573	-10			(5)				
				WA		15							
				84812		5							
<b>D3067-1</b> End Plate		Manufactured	No			110	Each	133.0000	1	5			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA	B90177	129			5				
				78608		4							
				83855		50							
				84534		75							
				WA016		4							
				67582		2							
				68214		1							
				79607		1							

B870735  
 Ac 12.09.23

12.10.11

# Picklist Print

July-05-12 10:51:59 AM

Work Order ID: 86572

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/05/12

Required Date: 7/20/12

Start Qty: 5.00

Required Qty: 5.00

D3219-1      Manufactured      No      110      Each      250.0000      2      10      12.10.11

Plate

Location	Loc Qty	Loc Code
WA <u>B88888</u>	191	
82221	74	
83852	117	
WA016	18	
73410	12	
77674	6	
WA017	41	
81971	41	

10

D3066-1      Manufactured      No      180      Each      99.0000      2      10

Spacer

Location	Loc Qty	Loc Code
ST176	31	
83854	31	
WA	68	
85449	68	

B90211 (x10)  
12.10.18

MS20600-AD4W4      Purchased      No      180      Each      3,202.0000      16      80

Rivets

Location	Loc Qty	Loc Code
321	878	
121652	878	
ST321	2324	
121011	9	
121340	315	
<u>121444</u>	2000	

80

# Picklist Print

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Work Order ID: 86572

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/05/12

Required Date: 7/20/12

Start Qty: 5.00

Required Qty: 5.00

D3065-041  
Step Leg Assembly Hi

Manufactured No

180 Each 73.0000 1 5

*B88822 x5*  
*Ac 12.10.18*

Location	Loc Qty	Loc Code
WA	73	
66149	0	
79336	1	
83870	32	
83871	40	

D3067-1  
End Plate

Manufactured No

180 Each 133.0000 1 5

*12.10.23*

Location	Loc Qty	Loc Code
WA <i>B90178</i>	129	
78608	4	
83855	50	
84534	75	
WA016	4	
67582	2	
68214	1	
79607	1	

*5*

*408-35A*  
Bolt

Purchased No

250 Each 76.0000 2 10

*m12352*

Location	Loc Qty	Loc Code
ST353	76	
121652	76	

*SmD*

*D3235-1*  
Mounting Lug

Manufactured No

250 Each 146.0000 2 10

*B70002 SP*

Location	Loc Qty	Loc Code
ST481	146	
83311	46	
83853	100	

*12-10-25*

*Smf*

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Shop Packet Print

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# Picklist Print

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Work Order ID: 86572

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/05/12

Required Date: 7/20/12

Start Qty: 5.00

Required Qty: 5.00

D3278-041

Manufactured No

250 Each 93.0000

0

5

Support Assembly

Location	Loc Qty	Loc Code
ST471	40	
83857	40	
ST481	53	
83856	13	
83858	40	

SMB

AN960JD416

NAS1149D0463J

Purchased

No

250 Each 29.0000

16

80

Washer

Location	Loc Qty	Loc Code
ST351	29	
116289	8	
119097	21	

SMD

AN960JD516

NAS1149D0563J

Purchased

No

250 Each 12.0000

4

20

Washer

Location	Loc Qty	Loc Code
ST338	12	
2612	12	

SMB

AN5-36A

Purchased

No

250 Each 224.0000

2

10

Bolt

Location	Loc Qty	Loc Code
340	74	
121652	74	
ST340	150	
121708	50	
122141	100	

SMB



# Picklist Print

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July-05-12 10:52:00 AM

Work Order ID: 86572

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/05/12

Required Date: 7/20/12

Start Qty: 5.00

Required Qty: 5.00

S S D2618 Bushing	Manufactured	No	250	Each	204.0000	2	10	B90104 SP
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST012	204				
			76130	2				
			83614	1				
S A D2230-3 Lug	Manufactured	No	250	Each	158.0000	4	20	B89082 SP
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST480	158				
			83261	2				
			84133	156				
S S D2856-400 Abrasion Strip cut (2) D2856-400-720 as per dwg L7 Maxon Sr 7/10/12	Manufactured	No	250	f	168.8425	0.2		B86905 SP
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST403	159.398				
			81875	159.398				
			ST409	9.4445				
			63735	0.6696				
			68076	0.3149				
S S MS2104213 Nut	Purchased	No	250	Each	3,330.0000	2	10	M123265 SP
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST300	1330				
			117885	32				
			119017	771				
			119075	138				
			121444	389				
			ST317	2000				
			122141	2000				

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Shop Packet Print

Page 5

# Picklist Print

Page 6

July-05-12 10:52:00 AM

Work Order ID: 86572

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/05/12

Required Date: 7/20/12

Start Qty: 5.00

Required Qty: 5.00

AN4-13A

Bolt

Purchased

No

250

Each

1,143.0000

8

40

m/22416 SP

## Location

## Loc Qty

## Loc Code

ST357

1143

120187

19

120422

2

120770

12

121652

912

122063

198

Smb

MS21042L3

Nut

Purchased

No

250

Each

1,224.0000

2

10

SP

## Location

## Loc Qty

## Loc Code

300

500

121652

500

ST300

724

108827

4

116105

5

116548

43

117611

2

119109

658

17651

4

2937

8

10X

Smb

MS21042L4

Nut

Purchased

No

250

Each

1,705.0000

8

40

m/22452 SP

## Location

## Loc Qty

## Loc Code

ST300

1705

119075

116

121011

193

121444

1096

121652

300

Smb

AN260JD10

Washer

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

20

m/23248

SP 12-10-25

see pg 1 for OSI kit

Shop Packet Print

July-05-12 10:52:00 AM

Smb Page 6



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**

*07.06.04*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

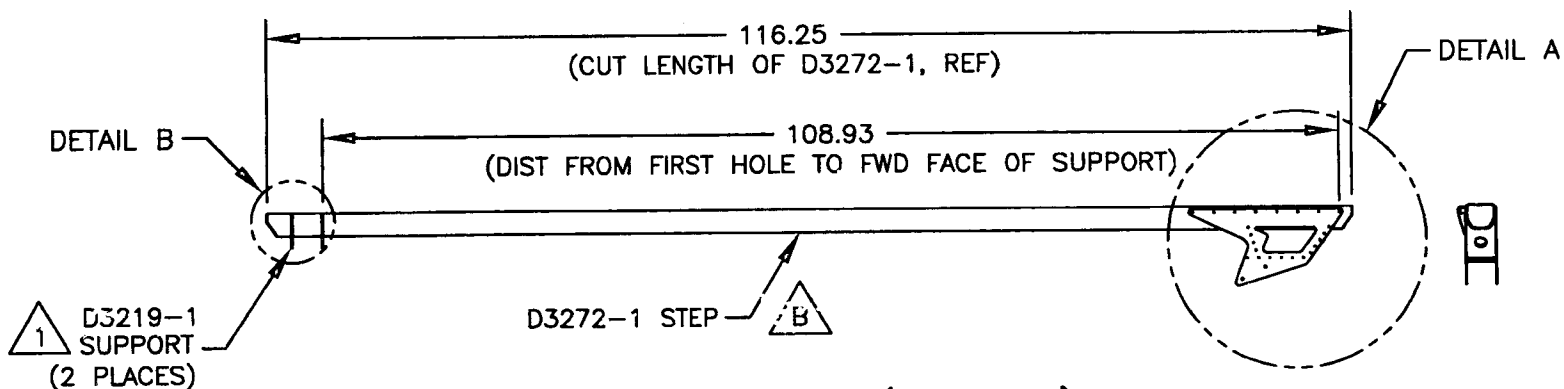
*4/08/05*

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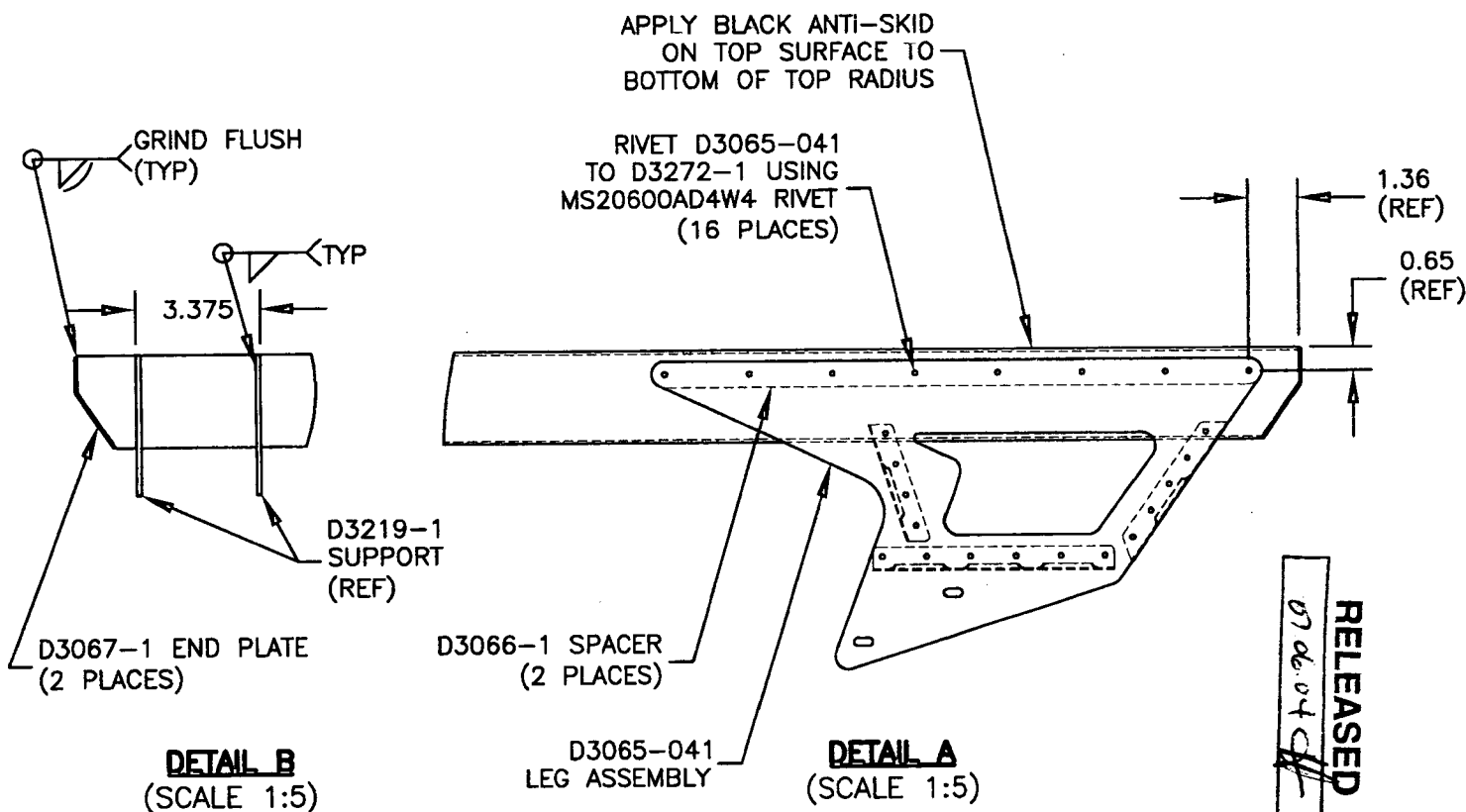
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DESIGN	AP	DRAWN BY	JB	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JB	HAMKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



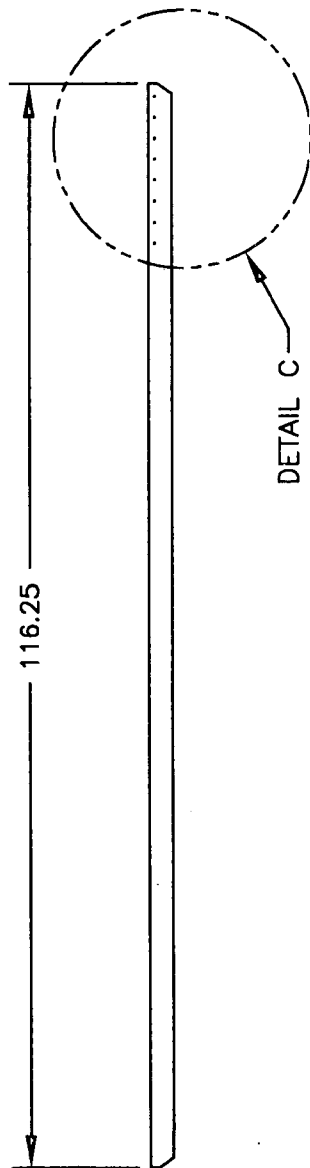




DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

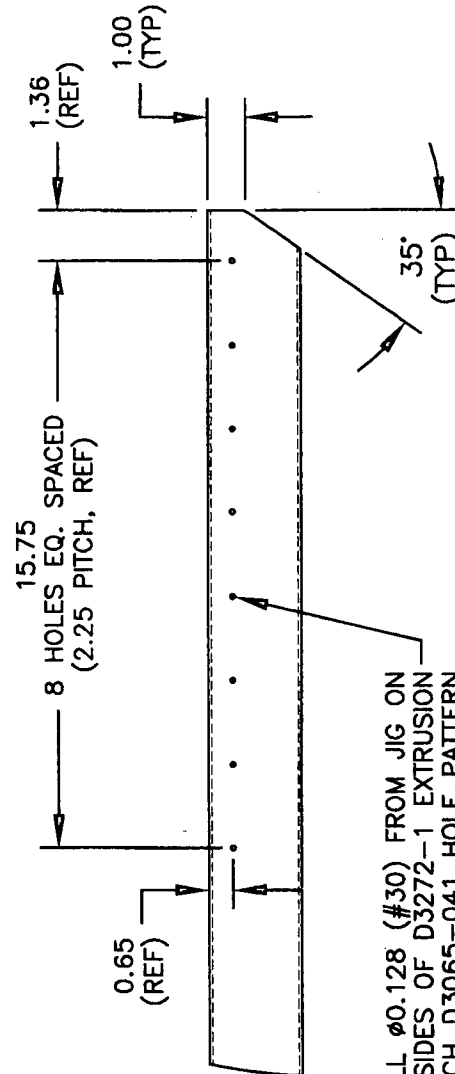
07.06.04 *[Signature]*



DETAIL C

**B** D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\phi 0.128$  (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**

(SCALE 1:5)

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION-STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4		8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.